

Ship June 3

Work Order ID 59163

Thursday, May 27, 2010 9:24:17 AM



Page 1

Item ID:	D3371-3	Accept		Setup	Start	
Revision ID:						
Item Name:	Pedal Lock Cover				Stop	
Start Date:	5/27/2010	Start Qty:	4.00			
Required Date:	6/4/2010	Req'd Qty:	4.00			
Reference:						
				Cust Item ID:		
				Customer:		

Approvals:	Process Plan:		Date:	10-5-27	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D3371	Rev B								

100		0.00							
	BAND SAW					4	Ø		
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	Cut blank: 2.00" x 2.25" x 7.370" long		N.A	10/06/01					

110		0.00							
	HAAS CNC VERTICAL MACHINING #1					4	Ø		
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	1-Machine D3371-3 as per Folio FA486 and Dwg D3371 2-Deburr 3-Finish 8-32 thread by hand Identify as D3371-3		N.A	10/06/02					

120		0.00							
	QC2- Inspect parts off machine FAI/FAIB					4	Ø		
QC	Memo	0.00							
Quality Control			N.A	10/06/02					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 59163

Thursday, May 27, 2010 9:24:17 AM



Page 2

Item ID: D3371-3

Accept



Setup Start

Revision ID:

Item Name: Pedal Lock Cover

Stop



Start Date: 5/27/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 6/4/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

10/06/02

4

0

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

10/06/03

4

0

145

Fire Red(Ref:4.3.5.10) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

cover inside holes prior painting

10/06/04

4

0

Start Time: 1:45 PM
Oven Temperature: 320° F
Finish Time: 2:15 AM

W/O:		WORK ORDER CHANGES					
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Page 3

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	QC: _____	Date: _____	SPC (Y/N): _____	Date: _____		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 	QC3- Inspect Part Finish	0.00							
QC Quality Control	Memo	0.00				(4X)			
160 	Identify as per dwg & Stock Location: B 59161	0.00							
Packaging Packaging	Memo	0.00							
170 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							

10/06/09

mr
10-6-9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, May 27, 2010 9:24:21 AM

Page 1

Work Order ID: 59163

Parent Item: D3371-3

Parent Item Name: Pedal Lock Cover

Comments: IPP A 05.01.18 New issue KJ/JLM

Start Date: 5/27/2010

Required Date: 6/4/2010

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B2.000X02.25 0		Purchased	No			100	f	0.8500	0.625	2.631579			



6061-T6 Bar 2.00 x 2.25



3.5
Jm
Spis Batel only

Location

Loc Qty

Loc Code

MAT09

0.85

16427

0.85

112764

2.6315^{ft}

h.A 10/06/01

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	5983
Description: Pedal Lock Cover		Part Number:	D3371-3
Inspection Dwg: D3371	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.450	+/-0.005	1.450	✓			
7°	+/-0.5°	7°	✓			
0.104	+/-0.010	0.096	✓			
0.305	+/-0.010	0.310	✓			
1.650	+/-0.010	1.650	✓			
1.30	+/-0.030	1.295	✓			
Ø1.000	+/-0.010	Ø1.005	✓			
45°	+/-0.5°	45°	✓			
Ø1.300	+/-0.010	Ø1.300	✓			
0.500	+/-0.010	0.502	✓			
60°	+/-0.5°	60°	✓			
2.25	+/-0.030	2.253	✓			
1.650	+/-0.010	1.650	✓			
3.950	+/-0.010	3.950	✓			
1.330	+/-0.005	1.331	✓			
7.19	+/-0.030	7.190	✓			
4.500	+/-0.010	4.495	✓			
0.635	+0.010/-0.000	0.636	✓			
1.125	+/-0.010	1.126	✓			
0.750	+/-0.010	0.750	✓			
Ø0.750	+0.010/-0.000	Ø0.760	✓			
3.625	+/-0.010	3.625	✓			
Ø1.200	+/-0.010	Ø1.200	✓			
0.750 deep	+/-0.010	0.750	✓			
0.500	+/-0.010	0.506	✓			
2.00	+/-0.030	2.000	✓			
1.000	+/-0.010	1.000	✓			
0.375	+/-0.010	0.375	✓			
Ø0.185	+0.005/-0.000	0.187	✓			
0.400 deep	+/-0.010	0.410	✓			

Measured by:	J.A
Date:	10/06/02

Audited by:	anf
Date:	10/06/02

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.26	New Issue	KJ/JLM	
B	05.05.25	Revised dimensions	KJ/JLM	

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

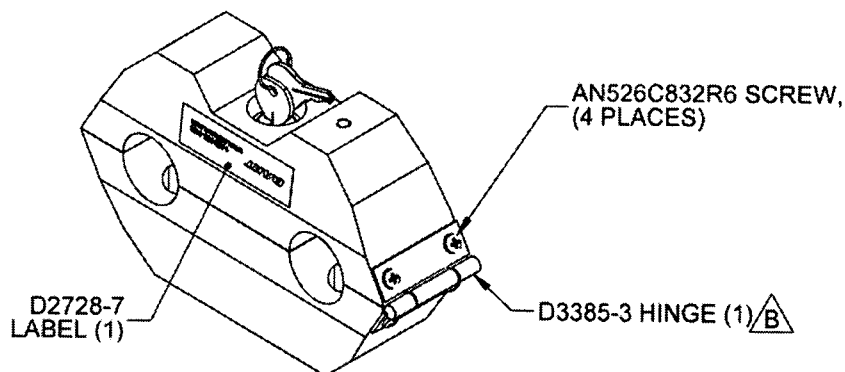
NOTE: Date & initial all entries



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3371	REV. B SHEET 1 OF 4
DATE 05.03.22		TITLE PEDAL LOCK	SCALE 1:3
A	04.12.06	NEW ISSUE	
B	05.03.22	D3385-3 WAS D3385-1	

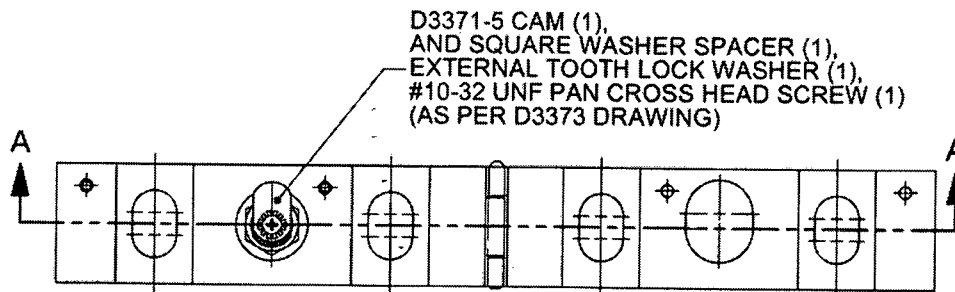
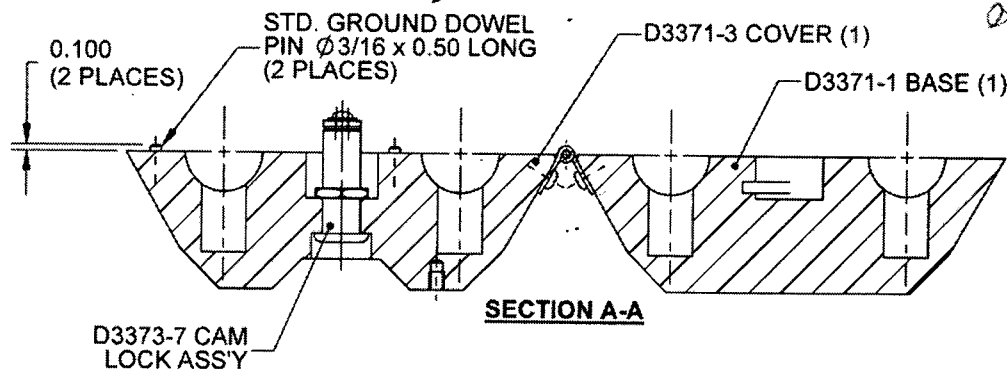
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 5943

pl 10-522



PEDAL LOCK SHOWN LOCKED WITH KEY

RELEASED
[Signature]
05/04/28



D3371-051 PEDAL LOCK ASSEMBLY

NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES

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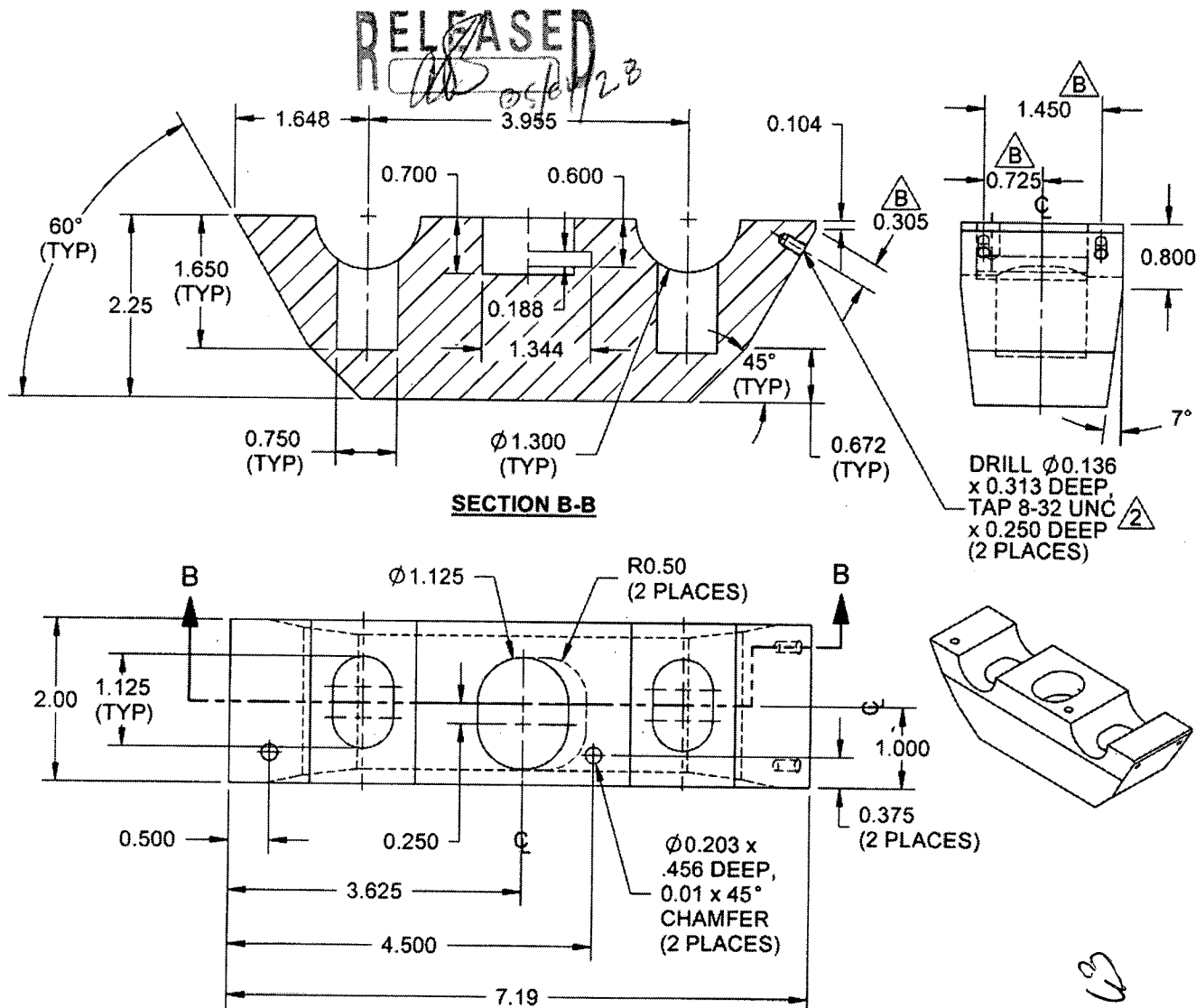
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3371	REV. B SHEET 2 OF 4
DATE 05.03.22	TITLE PEDAL LOCK		SCALE 1:2



NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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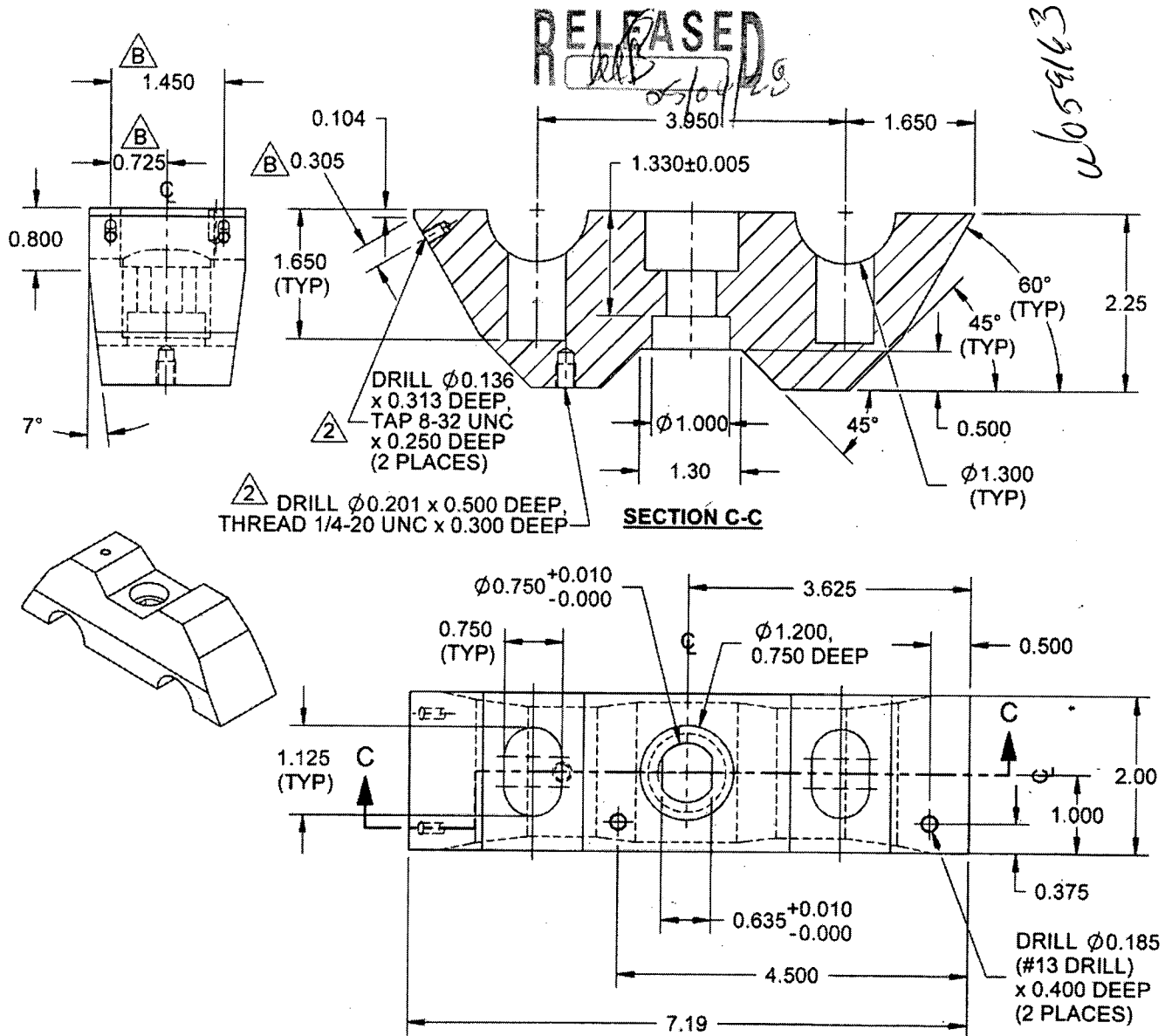
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3371	REV. B SHEET 3 OF 4
DATE 05.03.22	TITLE PÉDAL LOCK		SCALE 1:2

**D3371-3 COVER****NOTES:**

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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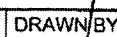


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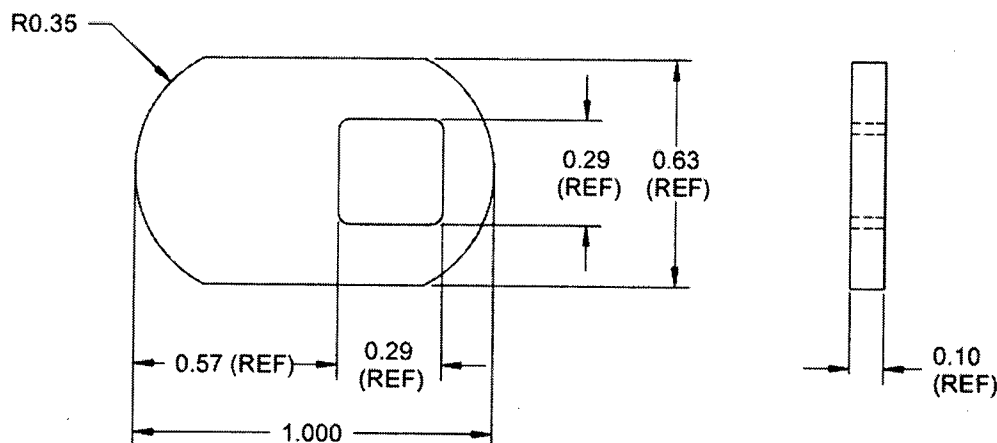
- NOTE: Date & initial all entries



DESIGN 	DRAWN BY 	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D3371	REV. B SHEET 4 OF 4
DATE 05.03.22		TITLE PEDAL LOCK	SCALE 2:1

RELEASED
[Signature]
05/04/28

SPECIFICATION CONTROL DRAWING



w/b 59163

D3371-5 CAM

NOTES:

- 1) MATERIAL: SUPPLIER BY D3373, MODIFIED AS SHOWN
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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